

Work Order ID 112555

112555

January-30-14 11:49:43 AM

Ship Monday

Page 1

Item ID: D3574-2

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Cabin Floor Protector

Stop

NS2

Start Date: 1/30/14 Start Qty: 2.00

2

Cust Item ID:

Required Date: 1/30/14 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: SA

Date: 14-02-03 Tooling:

Date:

Run

Start

NR1

QC: _____

Date: _____ SPC (Y/N):

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D3574	Rev B								

100

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3574

Dwg Rev: B

Prog Rev: B

2-Deburr

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

2 0 Jm14-04-8

2 0 Jm14-04-8

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only 

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General				
Bending	Bend	<input type="checkbox"/>	Outside Dimensions	<input type="checkbox"/>	Pressure/Forced
Centre Not Concentric	BOM/Route	<input type="checkbox"/>	Over/Under tolerance	<input type="checkbox"/>	Set-up
Cracks	Broken/Damage/Defect	<input type="checkbox"/>	Part Incorrect	<input type="checkbox"/>	Temperature/Cure
Crimp/Kink/Ripple/Wave	Burrs	<input type="checkbox"/>	Part Lost/Missing	<input type="checkbox"/>	Weld
Cuffs	Contamination	<input type="checkbox"/>	Part Moved	<input type="checkbox"/>	Wrong Stock Pulled
Crushing	Countersink	<input type="checkbox"/>	Positioned Wrong	<input type="checkbox"/>	
Heat Treat	Cut Too Short	<input type="checkbox"/>	Power Loss/Surge	<input type="checkbox"/>	Other
Inspection Strip in Tube	Drawing	<input type="checkbox"/>		<input type="checkbox"/>	
Marks/Chatter	Drill Holes	<input type="checkbox"/>		<input type="checkbox"/>	
Turning Sequence	Finish	<input type="checkbox"/>		<input type="checkbox"/>	
Wave/Twist in Tube	Fit/Function	<input type="checkbox"/>		<input type="checkbox"/>	

Work Order ID 112555***112555***

Page 2

January-30-14 11:49:43 AM

Item ID: D3574-2

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Cabin Floor Protector

Start Date: 1/30/14 Start Qty: 2.00

2

Cust Item ID:

Required Date: 1/30/14 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

120

QC

Quality Control

QC8- Inspect parts - second check

0.00

27

9.89

0.00

M4

18

2

130

130

Small Fab

Small Fab

Small Fab

Memo

Deburr if necessary.

0.00

0.00

DAS

27

9.89

0.00

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

DQA:

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only

Work Order: _____
 Part No. _____
 NCR No. _____

DISPOSITION

Rework
 Scrap
 Use-as-is
 Suspected Unapproved

AGAINST DEPARTMENT/PROCESS

Skid-tube
 Machining
 Thermoforming
 Large Fab

Crosstube
 Small Fab
 Finishing
 Composite

Water Jet
 Prod. Eng. Coor.
 Rec/Store/Packaging
 Supplier

Engineering
 Quality
 Other

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	Bending	General	Bend	Folio/Program	Outside Dimensions	Pressure/Forced
	Centre Not Concentric		BOM/Route	Grain	Over/Under tolerance	Set-up
	Cracks		Broken/Damage/Defect	Hardware	Part Incorrect	Temperature/Cure
	Crimp/Kink/Ripple/Wave		Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing	Weld
	Cuffs		Contamination	Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled
	Crushing		Countersink	Misaligned/off center	Positioned Wrong	
	Heat Treat		Cut Too Short	Mislabeled	Power Loss/Surge	Other
	Inspection Strip in Tube		Drawing	Misread		
	Marks/Chatter		Drill Holes	Off-set		
	Turning Sequence		Finish	Out of Calibration		
	Wave/Twist in Tube		Fit/Function	Out of Sequence		

Work Order ID 112555

112555

January-30-14 11:49:43 AM

Page 3

Item ID: D3574-2

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Cabin Floor Protector

Stop

NS2

Start Date: 1/30/14 Start Qty: 2.00

2

Cust Item ID:

Required Date: 1/30/14 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Identify as per dwg & Stock Location: _____

0.00

150

Packaging

Packaging

Memo

PP1112448

0.00

14/4/14 (2)

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Quality Control

Memo

0.00

MW 14-04-09

MF
14-4-8

DQA:

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only

Work Order: _____
 Part No. _____
 NCR No. _____

DISPOSITION

Rework
 Scrap
 Use-as-is
 Suspected Unapproved

AGAINST DEPARTMENT/PROCESS

Skid-tube	Crosstube	Water Jet	Engineering
Machining	Small Fab	Prod. Eng. Coor.	Quality
Thermoforming	Finishing	Rec/Store/Packaging	Other
Large Fab	Composite	Supplier	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear		General							
			Bend		Folio/Program			Outside Dimensions	Pressure/Forced
			BOM/Route		Grain			Over/Under tolerance	Set-up
			Broken/Damage/Defect		Hardware			Part Incorrect	Temperature/Cure
			Burrs		Inspection Incomplete/Unqualified			Part Lost/Missing	Weld
			Contamination		Instructions Incomplete/Unclear			Part Moved	Wrong Stock Pulled
			Countersink		Misaligned/off center			Positioned Wrong	
			Cut Too Short		Mislabeled			Power Loss/Surge	Other
			Drawing		Misread				
			Drill Holes		Off-set				
			Finish		Out of Calibration				
			Fit/Function		Out of Sequence				

Picklist Print

January-30-14 11:49:42 AM

Page 1

Work Order ID: 112555

Parent Item: D3574-2

Parent Item Name: Cabin Floor Protector

Start Date: 1/30/14

Required Date: 1/30/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev :A New Issue 07-01-22 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MLEXS.125-F60029-04
GE PLASTICS LEXAN SHEET

Purchased

No

sf 2,684.9900

51

JM14-04-8

Location

Loc Qty

Loc Code

MAT019

2684.9

124866

10

m12642

479.9

m12793

209

123934

DQA: _____ Date: _____

Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Date:

Work Order update only



Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework Scrap Use-as-is Suspected Unapproved	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other				
Part No. _____											
NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											
FAULT CATEGORY											
Landing Gear			General								
<input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			<input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function								
			<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence								
			<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge								
			<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled								
			<input type="checkbox"/> Other								

DART AEROSPACE LTD	Work Order:	112555
Description: Cabin Floor Protector	Part Number:	D3574-2
Inspection Dwg: D3574 Rev: B		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.003"	-		V	Jhm05
7.37	+/-0.030	7.37"	-		V	
10.75	+/-0.030	10.75"	-		V	Jhm08
11.00	+/-0.030	11.00"	-		V	
15.25	+/-0.030	15.25"	-		T	Jhm03
25.87	+/-0.030	25.87"	-		T	
39.75	+/-0.030	39.87"	-		T	
44.75	+/-0.030	44.75"	-		T	
53.51	+/-0.030	53.51"	-		T	
63.50	+/-0.030	63.50"	-		T	
65.25	+/-0.030	65.25"	-		T	
10.75	+/-0.030	10.75"	-		V	
11.00	+/-0.030	11.00"	-		V	
14.75	+/-0.030	14.75"	-		T	
25.50	+/-0.030	25.50"	-		T	
25.75	+/-0.030	25.75"	-		T	
26.00	+/-0.030	26.00"	-		T	
32.87	+/-0.030	32.87"	-		T	
38.81	+/-0.030	38.81"	-		T	
45.00	+/-0.030	45.00"	-		T	
48.25	+/-0.030	48.25"	-		T	
58.38	+/-0.030	58.38"	-		T	
61.25	+/-0.030	61.25"	-		T	
64.13	+/-0.030	64.13"	-		T	
64.63	+/-0.030	64.63"	-		T	
66.50	+/-0.030	66.50"	-		T	
7.50	+/-0.030	7.50"	-		V	
9.50	+/-0.030	9.50"	-		V	
10.38	+/-0.030	10.38"	-		V	
10.88	+/-0.030	10.88"	-		V	
14.50	+/-0.030	14.50"	-		T	
16.56	+/-0.030	16.56"	-		T	
18.75	+/-0.030	18.75"	-		T	
24.13	+/-0.030	24.13"	-		T	

DART AEROSPACE LTD		Work Order:	112SSS
Description: Cabin Floor Protector		Part Number:	D3574-2
Inspection Dwg: D3574	Rev: B		Page 2 of 2

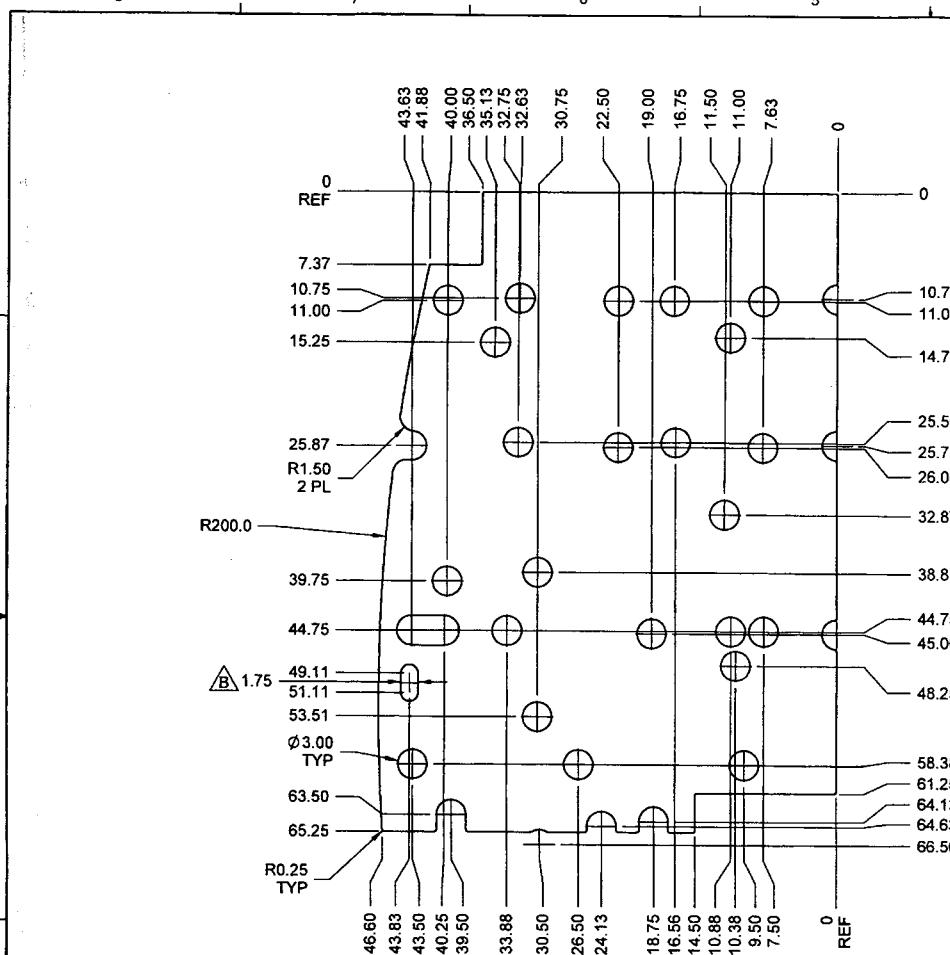
FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
26.50	+/-0.030	26.50"	-		T	
30.50	+/-0.030	30.50"	-		T	
33.88	+/-0.030	33.88"	-		T	
39.50	+/-0.030	39.50"	-		T	
40.25	+/-0.030	40.15"	-		T	
43.50	+/-0.030	43.50"	-		T	
46.60	+/-0.030	46.60"	-		T	
7.63	+/-0.030	7.63"	-		V	
11.00	+/-0.030	11.00"	-		V	
11.50	+/-0.030	11.50"	-		V	
16.75	+/-0.030	16.75"	-		T	
19.00	+/-0.030	19.00"	-		T	
22.50	+/-0.030	22.50"	-		T	
30.75	+/-0.030	30.75"	-		T	
32.63	+/-0.030	32.63"	-		T	
32.75	+/-0.030	32.75"	-		T	
35.13	+/-0.030	35.13"	-		T	
36.50	+/-0.030	36.50"	-		T	
40.00	+/-0.030	40.00"	-		T	
41.88	+/-0.030	41.88"	-		T	
43.63	+/-0.030	43.63"	-		T	
0.125	+/-0.010	0.125"	-		V	

Measured by:	JM	Audited by:	27 9.09	Prototype Approval:	N/A
Date:	14-04-8	Date:	14/4/8	Date:	N/A

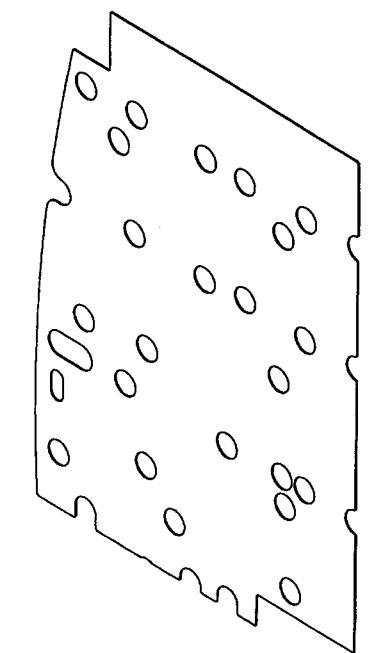
Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ//DD	
B	08.07.31	47.75 dimension removed	KJ/DD	
C	09.05.15	Dimensions updated per Dwg Rev B	KJ	df



D3574-1 CABIN FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-1" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.30 lbs
- 8) CHECK PER TEMPLATE DT8961

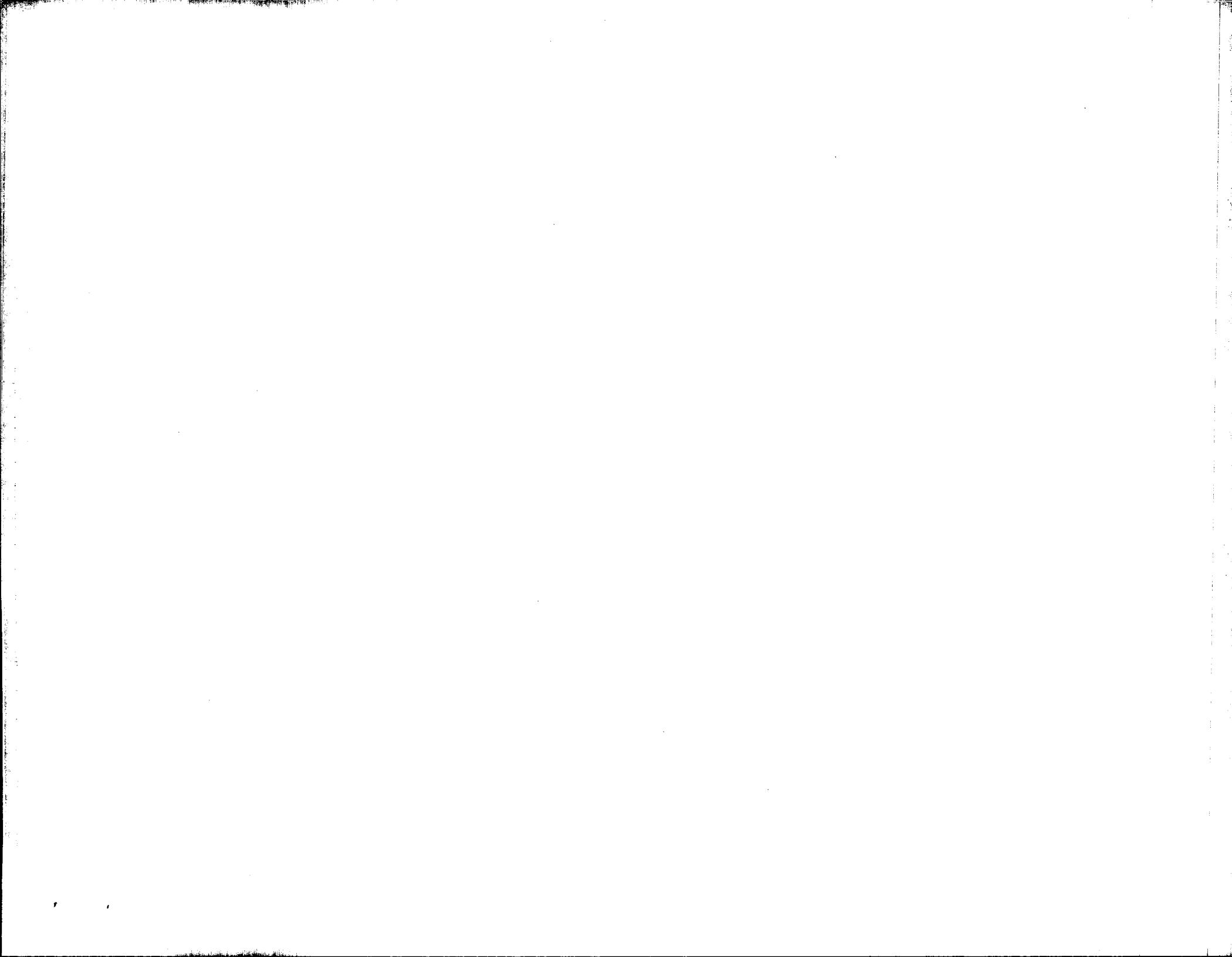


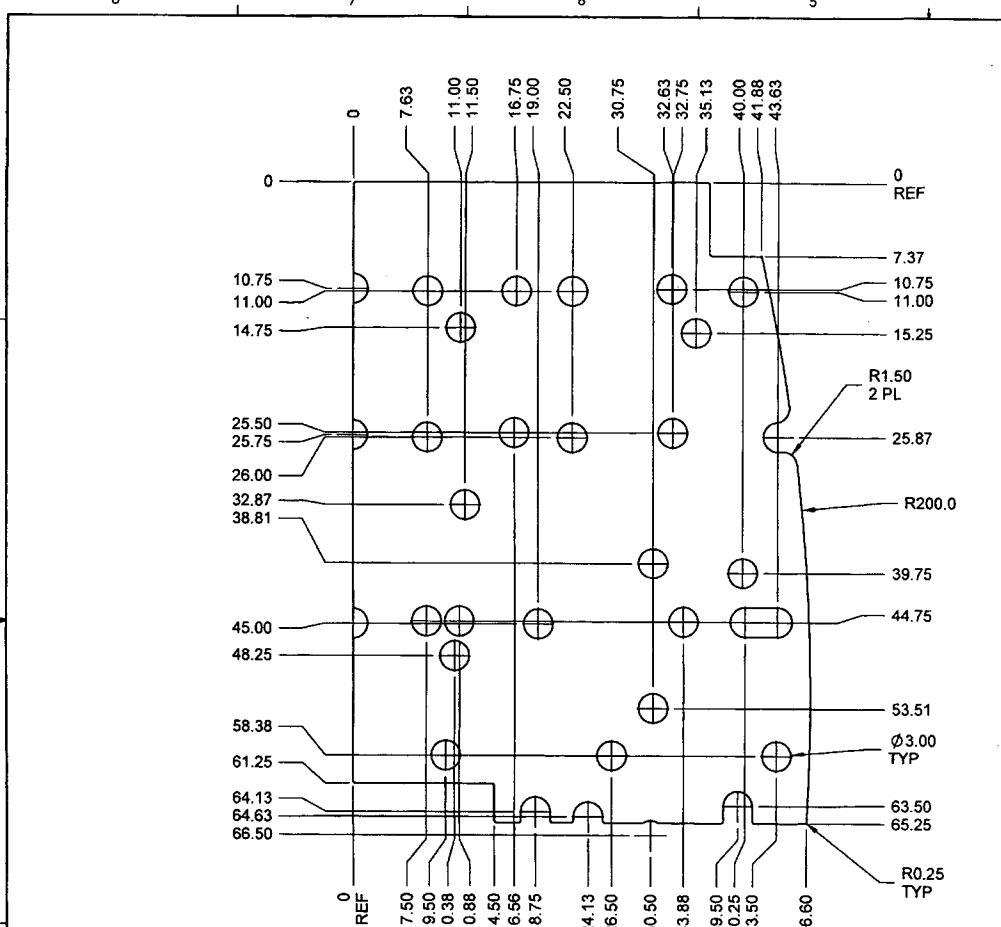
112555 20
14-02-03

RELEASED
09/04/07

B	ADD CUT-OUT TO -1/-5 FOR WEIGHT AND BALANCE DATA PLATE ZN B7-1, B8-5, -2 NOW SHOWN ON SHEET 2				09.03.25
A	NEW ISSUE			CB	07.06.08
REV.	DESCRIPTION			BY	DATE
DESIGN				DART AEROSPACE LTD	
DRAWN				HAWKESBURY, ONTARIO, CANADA	
CHECKED				DRAWING NO.	
MFG. APPR.				REV. B	
APPROVED				D3574	
DE APPR.				SHEET 1 OF 6	
DATE	09.03.25			TITLE	
				SCALE	
				CABIN FLOOR PROTECTOR	
				NTS	

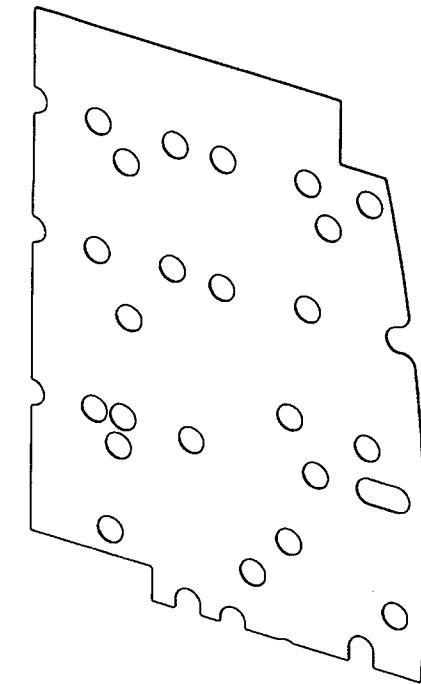
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NOTES:

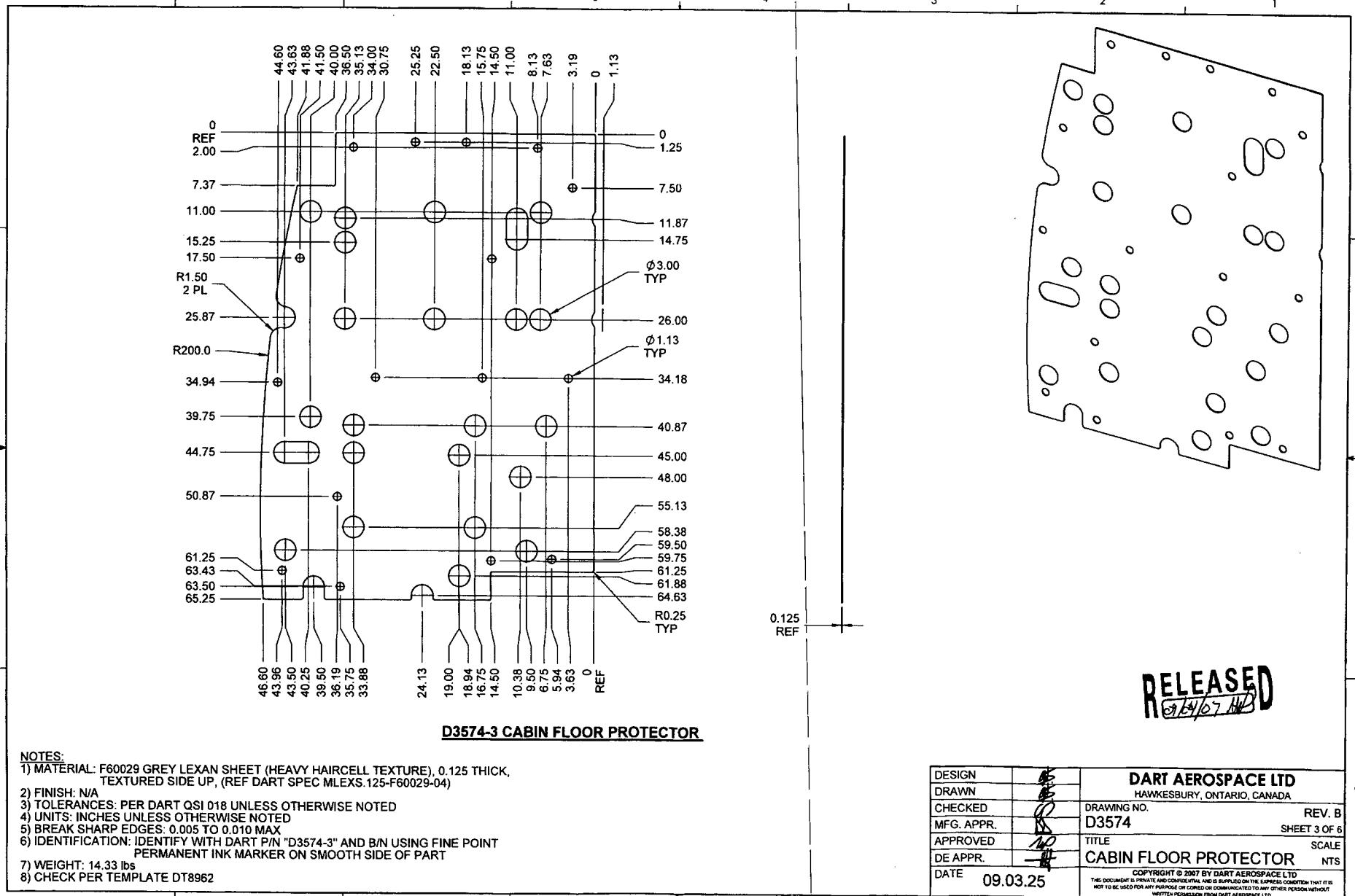
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-2" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.30 lbs
- 8) CHECK PER TEMPLATE DT8961



RELEASED
07/04/07 JWD

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO.
MFG. APPR.	<i>[Signature]</i>	REV. B
APPROVED	<i>[Signature]</i>	SHEET 2 OF 6
DE APPR.	<i>[Signature]</i>	TITLE
DATE	09.03.25	SCALE

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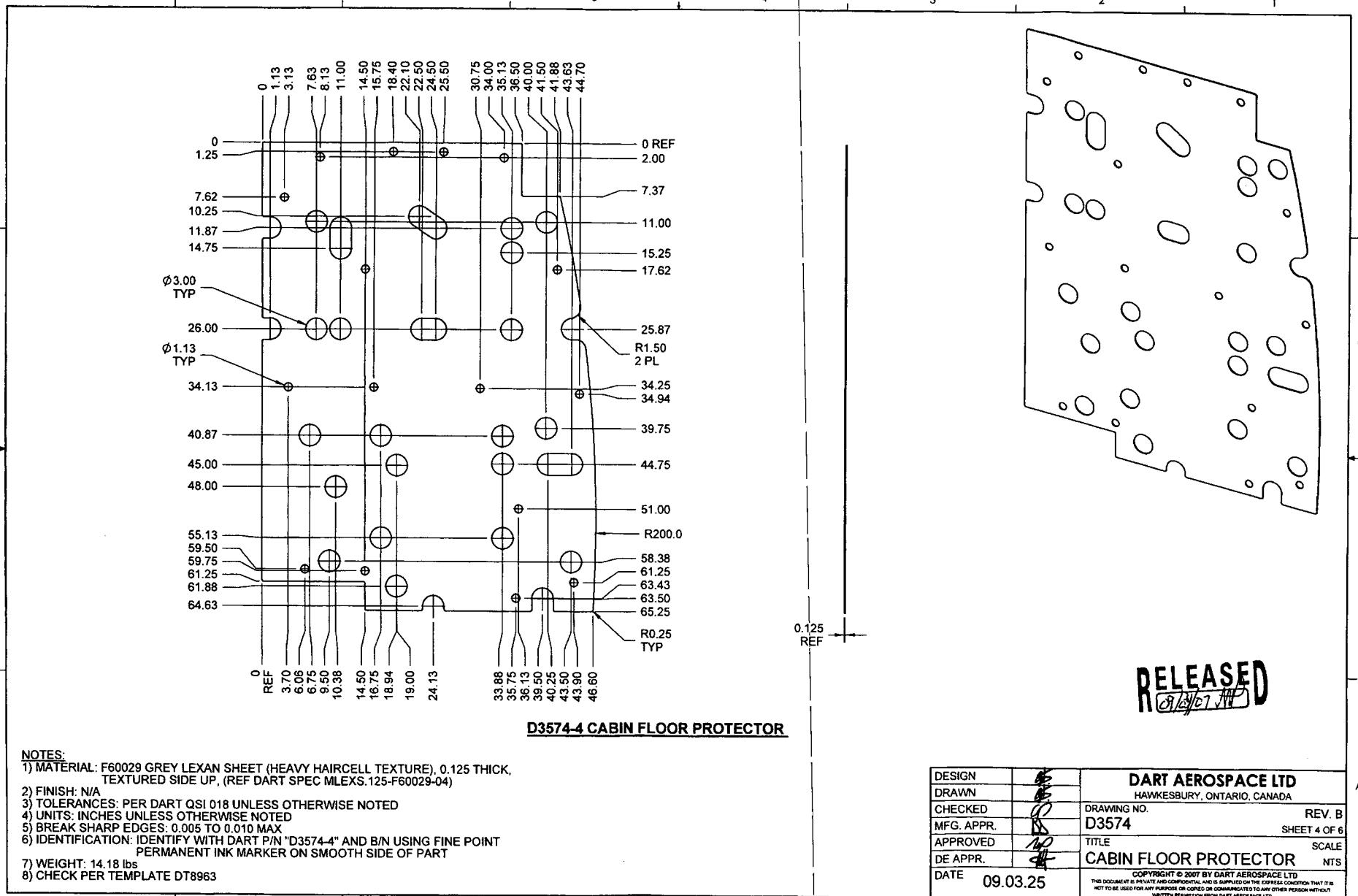


NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-3" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.33 lbs
- 8) CHECK PER TEMPLATE DT8962

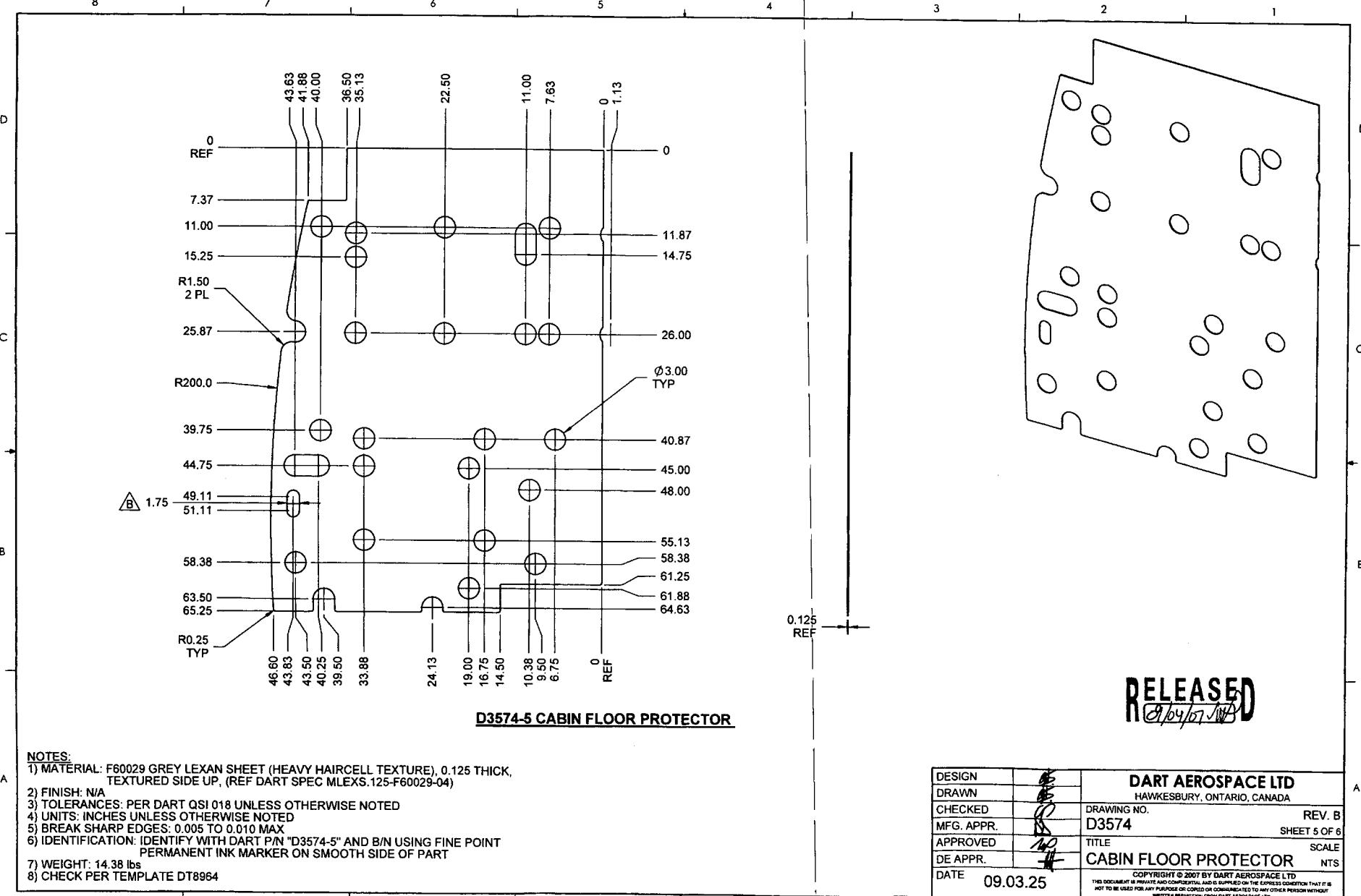
D3574-3 CABIN FLOOR PROTECTOR

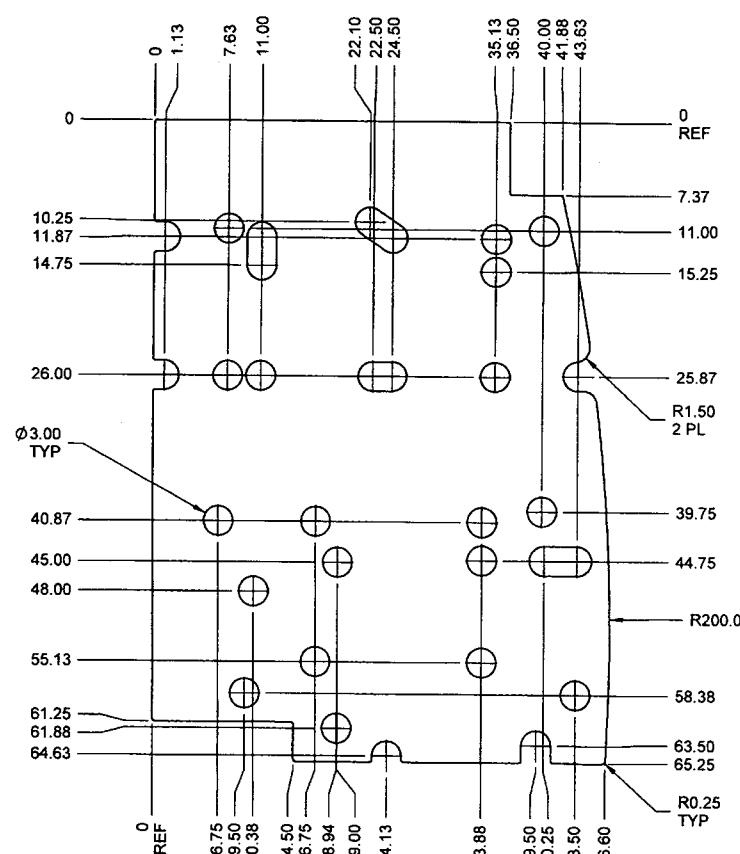
DESIGN	05	DART AEROSPACE LTD		
DRAWN	05	HAWKESBURY, ONTARIO, CANADA		
CHECKED	00	DRAWING NO.	REV. B	
MFG. APPR.	DS	D3574	SHEET 3 OF 6	
APPROVED	100	TITLE	SCALE	
DE APPR.	100	CABIN FLOOR PROTECTOR NTS		
DATE	09.03.25	COPYRIGHT © 2007 BY DART AEROSPACE LTD		
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DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO. D3574 REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 4 OF 6
APPROVED	<i>[Signature]</i>	TITLE CABIN FLOOR PROTECTOR NTS
DE APPR.	<i>[Signature]</i>	DATE 09.03.25

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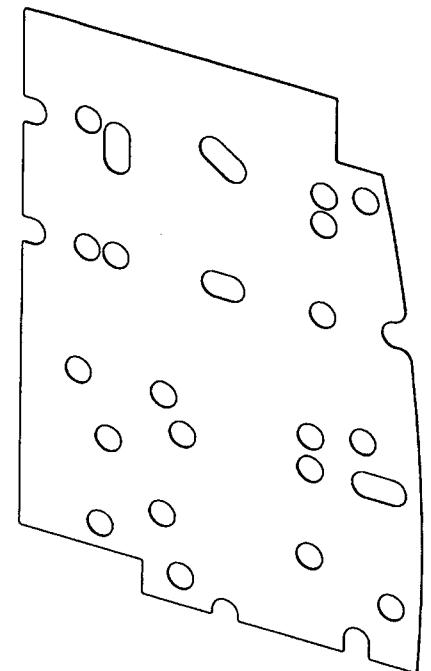




D3574-6 CABIN FLOOR PROTECTOR

NOTES:

NOTE: 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-6" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
7) WEIGHT: 14.27 lbs
8) CHECK PER TEMPLATE DT8965



RELEASER
09/04/07 JMH

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3574	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		CABIN FLOOR PROTECTOR	
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